

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007995**Date Inspected:** 10-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower&OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY#10

Ultrasonic Inspection

This Q.A Inspector performed Ultrasonic Inspection of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the stiffener of North tower, Lift4 Designation are as follows.

NSD1-FCSA4-1C/C-7A, 8A, 9A, 18A, 21A, 22A, 23A

NSD1-FCSA4-1B/C-4A, 7A, 8A, 9A

NSD1-FDSA4-3D/D-4A, 7A, 8A, 9A

BAY#2

Ultrasonic Inspection

This Q.A Inspector performed Ultrasonic Inspection of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The

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members are identified as the Floor beam Designation are as follows.

FB028-010-126

BAY#3

Ultrasonic Inspection

This Q.A Inspector performed Ultrasonic Inspection of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (U.T) report for this date. The members are identified as the Floor beam Designation are as follows.

FB015-041-045; FB015-040-045

FB011-039-043; FB011-036-045

FB009-038-043; FB011-038-045

FB016-041-045; FB012-034-043

This QA Inspector randomly observed the following work in progress.

BAY#11

FCAW welding process of weld joint 2 located on PCMK ESD1-FCSA4-2B/C. Welder is identified as 066479 ZPMC QC is identified as Zhong Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 3 located on PCMK ESD1-FCSA4-2B/C. Welder is identified as 066484 ZPMC QC is identified as Zhong Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

FCAW welding process of weld joint 19 located on PCMK ESD1-FCSA4-2C/C. Welder is identified as 069043 ZPMC QC is identified as Zhong Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F.

BAY#10

FCAW welding process of weld joint 70 located on PCMK SSTL3-1C/K. Welder is identified as 040450 ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-3312-TC-P4.

FCAW welding process of weld joint 74 located on PCMK SSTL3-1I/K. Welder is identified as 050038 ZPMC QC is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-3312-TC-P4.

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BAY#3

FCAW welding process of weld joint 49 located on PCMK FB003-190. Welder is identified as 044824 ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-3.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang + (86) 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar, Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
